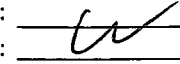


Date: Friday, 10/12/2007 1:11:55 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 35157		
Estimate Number	: 11471		
P.O. Number	:	Part Number	: D3140101
This Issue	: 10/12/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3140REV F
First Issue	: / /	Project Number	: N/A
Previous Run	: 31464	Drawing Revision	: F
	Type : SMALL / MED FAB	Material	:
Written By	: 	Due Date	: 10/19/2007
Checked & Approved By	:	Qty:	8
Comment	Um: Each		
	: Est. A 02.04.30 New Issue NG		
	: Est. B 06.04.18 New dwg rev. ecn781 EC		
	: Est. rev.C added scuffing NCR 061 EC		
	: Est Rev:D As per ECN #829 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0466 sf(s)/Unit Total : 0.3730 sf(s)
 2024-T3 .032 sheet
 Matl: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032)

Batch M10S SSC - 07-10-15

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3140
 Dwg Rev: F 18 07-10-15
 Prog Rev: F

2-Deburr if necessary

18-07-10-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

18 07-10-15**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

En 07/10/15 (18) countes

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/12/2007 1:11:55 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35157

Part Number: D3140101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

gdm 07/10/15 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-10-31 (8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL07110131 (8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CL07110131 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.01 *JA*

Job Completion



CL0711101

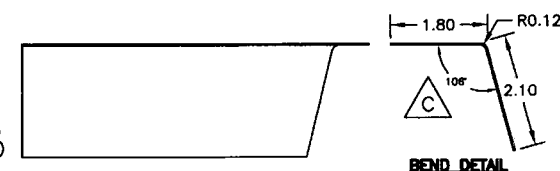
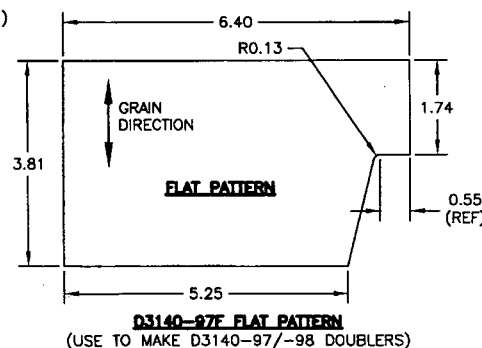
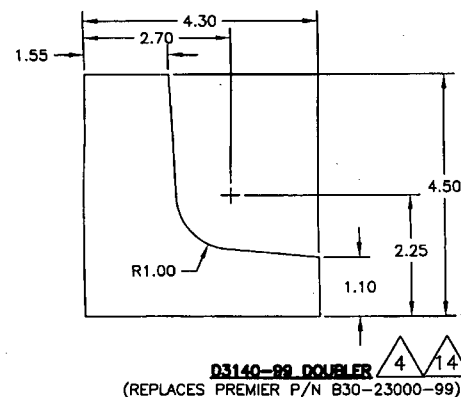
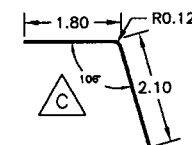
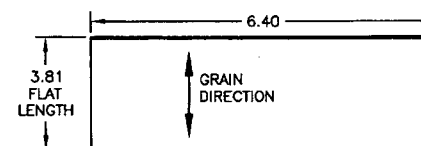
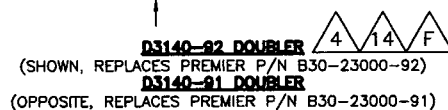
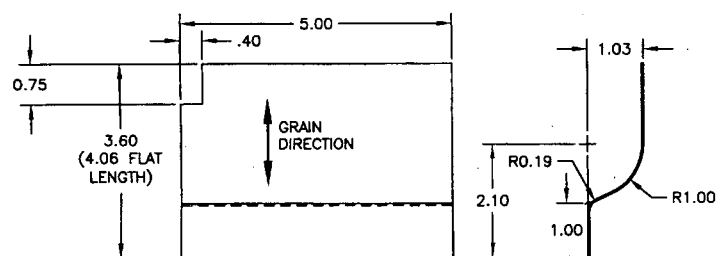
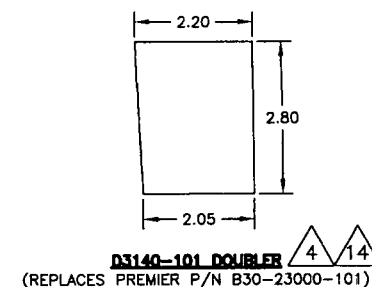
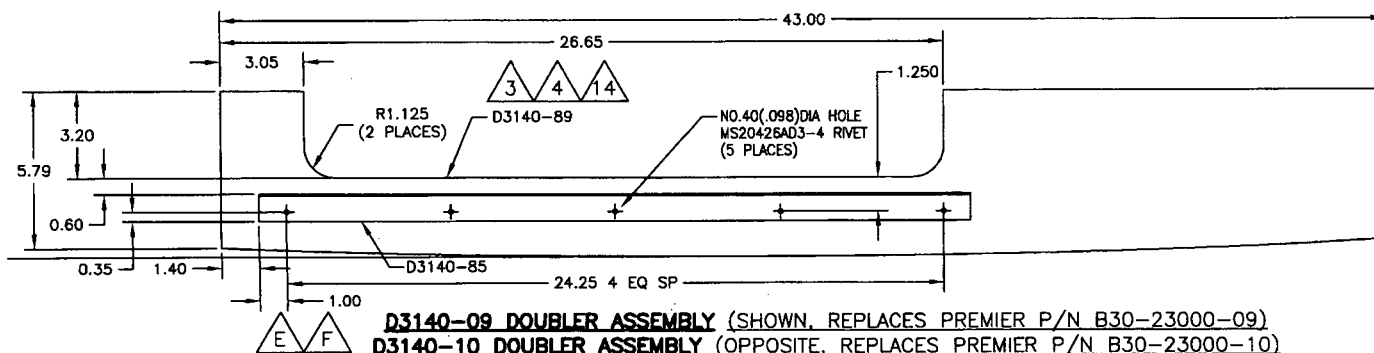
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

06.11.13

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DESIGN 4	DRAWN BY C.B.	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA	REV. F
CHECKED J.H.	APPROVED H.H.	DRAWING NO. D3140	SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

